

Work Order ID 162718

Friday, June 09, 2017 10:40:27 AM

162718

Page 1

Item ID: D4820-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Fpc Clip Base
 Start Date: 6/9/2017 Start Qty: 30.00 *30* Cust Item ID:
 Required Date: 7/18/2017 Req'd Qty: 30.00 *30* Customer:
 Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4820	A								

100 FLOW WATER JET 0.00
 100
 Waterjet Memo 0.73
 FLOW CNC Waterjet 1-Cut as per Dwg D4820
 Dwg Rev: A
 Prog Rev: A
 2-Deburr as required
 110 QC2- Inspect parts off machine FAI/FAIB 0.00
 110
 QC Memo 0.30
 Quality Control

(32) _____ 06/17/09

(32) _____ 06/17/09

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N900040100

Setup Start *NS1*

Stop *NS2*

30

Cust Item ID:

30

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Operation Description

Set Up/ Run Hours

Tool ID**Tool #****Plan
Code**

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.60

Quality Control

JUN 12 2017

130

0.00

130

Small Fab

Memo

0.52

Small Fab

C'sink hole as per dwg

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.60

Quality Control

DA-
38
9-61
JUN 16 2017

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Item ID: D4820-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Fpc Clip Base

Start Date: 6/9/2017 Start Qty: 30.00

30

Cust Item ID:

Required Date: 7/18/2017 Req'd Qty: 30.00

30

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

Identify as per dwg & Stock Location: _____

0.00

180

Packaging

Packaging

Memo

LOCATION : GA

0.30

32

JUN 19 2017

DAS

6

9-89

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Quality Control

Memo

3.00

17/6/21

DAS

21

9-89 JUN 19 2017

Picklist Print

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Work Order ID: 162718

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Parent Item: D4820-1

D4820-1

Parent Item Name: Fpc Clip Base

Start Date: 6/9/2017

Required Date: 7/18/2017

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP REV:A NEW ISSUE 13-04-15 JLM VERIFIED BY:DD

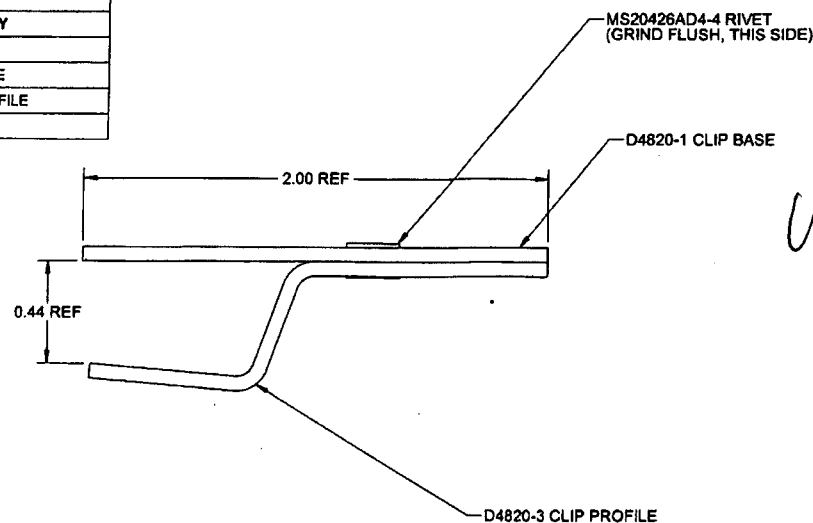
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased		No		100	sf	78.7620	0.02	0.631579			
M304S16GA									**				
304/316 Sheet .063													

06/17/06/07

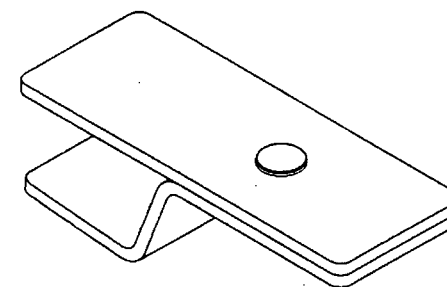
Location	Loc Qty	Loc Code
MAT010	78.762	
m136896	0.3	
m137110	0.532	
m137175	1.1	
m137263	0.27	
m137341	5.7	
m137400	70.86	

28.4
.4

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4820-041	CLIP ASSY
1	1	D4820-1	CLIP BASE
2	1	D4820-3	CLIP PROFILE
3	1	MS20426AD4-4	RIVET



W/O 162718



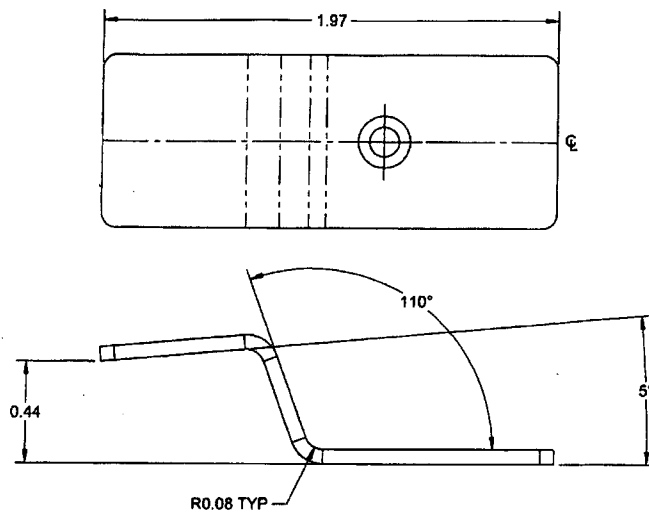
D4820-041 CLIP ASSY

RELEASED
2013-04-18
mp

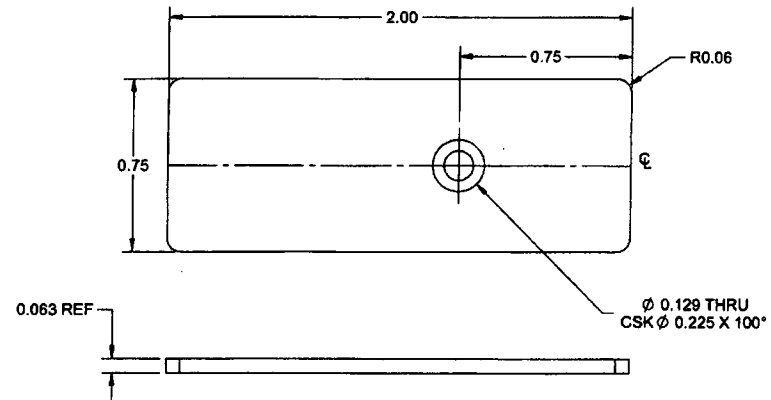
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4820-041" USING FINE POINT PERMANENT MARKER, QSI 044, METHOD 6.1
- 7) WEIGHT: 0.06 lbs

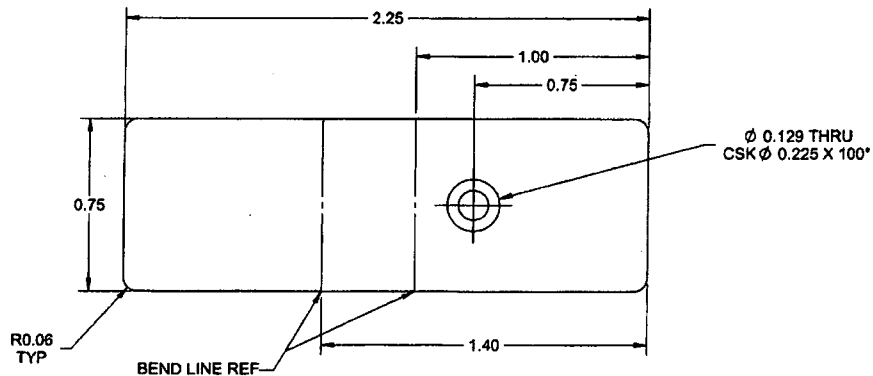
A	NEW ISSUE	DB	13.04.10
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	<i>AP</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>AP</i>	D4820	SHEET 1 OF 2
APPROVED	<i>AP</i>	TITLE	SCALE
DE APPR.	<i>AP</i>	CLIP ASSY	NTS
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D4820-3 CLIP PROFILE
(MAKE FROM D4820-3F)



D4820-1 CLIP BASE



D4820-3F FLAT PATTERN

RELEASED
2013-04-18

NOTES:

- 1) MATERIAL: AISI 304/316 SS, 0.063" THICK AS PER DART SPEC M304S18GA1P OR MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D4820-1: 0.03 lbs, D4820-3: 0.03lbs

DESIGN	DB	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AR	DRAWING NO.	REV. A
MFG. APPR.		D4820	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		CLIP ASSY	NTS
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